

**Work Order ID 113663**

February-24-14 10:00:56 AM

**\*113663\***

Page 1

Item ID: D3543-3

Revision ID:

Item Name: Hinge Panel Door Push-Out Frame

Start Date: 2/24/14 Start Qty: 4.00

Required Date: 2/24/14 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: MLJ

Date: 14-02-25

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Stop **\*NS2\***

Cust Item ID:

Customer:

QC: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling:

SPC (Y/N):

Date: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

**\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3543	Rev B								

100

**\*100\***

Waterjet

FLOW CNC Waterjet

2024-06-3

FLOW WATER JET

Memo

1-Cut as per Dwg D3543 Dwg Rev: B Prog Rev: B 2-  
Deburr if necessary

110

**\*110\***

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

12

17/05/08

m/b.n

0.00

12

17/05/08

m/b.n

120

**\*120\***

QC

Quality Control

QC8- Inspect parts - second check

0.00

Skf  
14/Skf

12

17/05/08

m/b.n

DQA:

Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: \_\_\_\_\_

Work Order update only 

Work Order: _____	<b>DISPOSITION</b>			<b>AGAINST DEPARTMENT/PROCESS</b>					
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									
<b>FAULT CATEGORY</b>									
Landing Gear	General			Folio/Program			Outside Dimensions		
	<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Pressure/Forced			
	<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Set-up	<input type="checkbox"/> Temperature/Cure			
	<input type="checkbox"/> Cracks	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Weld	<input type="checkbox"/> Wrong Stock Pulled			
	<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved	<input type="checkbox"/> Other				
	<input type="checkbox"/> Cuffs	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong					
	<input type="checkbox"/> Crushing	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge					
	<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread						
	<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set						
	<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration						
	<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence						
	<input type="checkbox"/> Wave/Twist in Tube								

**Work Order ID 113663**

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**\*113663\***

Page 2

Item ID: D3543-3

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Hinge Panel Door Push-Out Frame

Stop

**\*NS2\***Start Date: 2/24/14 Start Qty: 4.00 **\*4\***

Cust Item ID:

Required Date: 2/24/14 Req'd Qty: 4.00 **\*4\***

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	<b>*NR1*</b>
	QC:	Date:	SPC (Y/N):	Date:		Stop	<b>*NR2*</b>

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00							

**\*130\***

HandFinish

Hand Finishing

140

QC3- Inspect Part Finish

0.00

12 76145-10**\*140\***

QC

Quality Control

12 Q 14/05/12

150

Identify as per dwg & Stock Location: STO47 0.00

0.00

**\*150\***

Packaging

Packaging

Memo

12X 14-5-12.

DAS

26

9-89

DQA:

Date:



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only 

Work Order: _____	<b>DISPOSITION</b>			<b>AGAINST DEPARTMENT/PROCESS</b>					
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									
<b>FAULT CATEGORY</b>									
Landing Gear	Bending <input type="checkbox"/>	General			Folio/Program <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>		
	Centre Not Concentric <input type="checkbox"/>	Bend <input type="checkbox"/>	Grain <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Set-up <input type="checkbox"/>				
	Cracks <input type="checkbox"/>	BOM/Route <input type="checkbox"/>	Hardware <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>				
	Crimp/Kink/Ripple/Wave <input type="checkbox"/>	Broken/Damage/Defect <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Weld <input type="checkbox"/>				
	Cuffs <input type="checkbox"/>	Burrs <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Moved <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>				
	Crushing <input type="checkbox"/>	Contamination <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>					
	Heat Treat <input type="checkbox"/>	Countersink <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>	Other <input type="checkbox"/>				
	Inspection Strip in Tube <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Misread <input type="checkbox"/>						
	Marks/Chatter <input type="checkbox"/>	Drawing <input type="checkbox"/>	Off-set <input type="checkbox"/>						
	Turning Sequence <input type="checkbox"/>	Drill Holes <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>						
	Wave/Twist in Tube <input type="checkbox"/>	Finish <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>						
		Fit/Function <input type="checkbox"/>							

**Work Order ID 113663**

February-24-14 10:05:56 AM

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**Item ID:** D3543-3

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

**Revision ID:**

**Item Name:** Hinge Panel Door Push-Out Frame

Stop

**\*NS2\***

**Start Date:** 2/24/14      **Start Qty:** 4.00

**\*4\***

**Cust Item ID:**

**Required Date:** 2/24/14      **Req'd Qty:** 4.00

**\*4\***

**Customer:**

**Reference:**

**Approvals:** Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

**\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

**\*NR2\***

**Sequence ID/  
Work Center ID**

**Operation  
Description**

160

QC21- Final Inspection - Work Order Release

**Set Up/  
Run Hours**

**Tool ID**

**Tool #**

**Plan  
Code**

**Accept  
Qty**

**Reject  
Qty**

**Reject  
Number**

**Insp.  
Stamp**

0.00

0.00

MLJ 14-05-12

**\*160\***

QC

Quality Control

Memo

AT 14-05-12

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Date:



## **WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date:

## Work Order update only

Work Order update only				DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Work Order:				Rework		Skid-tube		Crosstube		Water Jet		Engineering	
Part No.				Scrap		Machining		Small Fab		Prod. Eng. Coor.		Quality	
NCR No.				Use-as-is		Thermoforming		Finishing		Rec/Store/Packaging		Other	
				Suspected Unapproved		Large Fab		Composite		Supplier			
Root Cause	Date	Step	Qty	Description of work order update or non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector		
Design													
Doc/Data													
Equip/Tooling													
Handling/Pre													
Material													
Operator													
Offset/Setup													
Process													
Supplier													
Training													
Transport													
Unapproved													
FAULT CATEGORY													
Landing Gear				General									
Bending		Bend		Folio/Program		Outside Dimensions		Pressure/Forced					
Centre Not Concentric		BOM/Route		Grain		Over/Under tolerance		Set-up					
Cracks		Broken/Damage/Defect		Hardware		Part Incorrect		Temperature/Cure					
Crimp/Kink/Ripple/Wave		Burrs		Inspection Incomplete/Unqualified		Part Lost/Missing		Weld					
Cuffs		Contamination		Instructions Incomplete/Unclear		Part Moved		Wrong Stock Pulled					
Crushing		Countersink		Misaligned/off center		Positioned Wrong							
Heat Treat		Cut Too Short		Mislabeled		Power Loss/Surge							
Inspection Strip in Tube		Drawing		Misread				Other					
Marks/Chatter		Drill Holes		Off-set									
Turning Sequence		Finish		Out of Calibration									
Wave/Twist in Tube		Fit/Function		Out of Sequence									

# Picklist Print

February-24-14 10:00:55 AM

Page 1

Work Order ID: 113663

\*113663\*  
\*D3543-3\*

Parent Item: D3543-3

Parent Item Name: Hinge Panel Door Push-Out Frame

Start Date: 2/24/14

Required Date: 2/24/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-11-14 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			100	sf	138.1339	2.5339	10.66905	**	17/05/08 MM/J.D.	

\*M2024T3S 063\*

2024-T3 .063 sheet

Location	Loc Qty	Loc Code
MAT022	138.1339	
123701	16.1039	
m127866	122.03	
m128354		34.8

DQA:

Date:



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only

Work Order: _____	<b>DISPOSITION</b>			<b>AGAINST DEPARTMENT/PROCESS</b>					
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									
<b>FAULT CATEGORY</b>									
Landing Gear	Bending <input type="checkbox"/>	General			Folio/Program <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>		
	Centre Not Concentric <input type="checkbox"/>	Bend <input type="checkbox"/>	BOM/Route <input type="checkbox"/>	Grain <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Set-up <input type="checkbox"/>			
	Cracks <input type="checkbox"/>	Broken/Damage/Defect <input type="checkbox"/>	Burrs <input type="checkbox"/>	Hardware <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>			
	Crimp/Kink/Ripple/Wave <input type="checkbox"/>	Contamination <input type="checkbox"/>	Countersink <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Weld <input type="checkbox"/>			
	Cuffs <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Drawing <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Moved <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>			
	Crushing <input type="checkbox"/>	Drill Holes <input type="checkbox"/>	Drill Holes <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>				
	Heat Treat <input type="checkbox"/>	Finish <input type="checkbox"/>	Fit/Function <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>	Other <input type="checkbox"/>			
	Inspection Strip in Tube <input type="checkbox"/>			Misread <input type="checkbox"/>					
	Marks/Chatter <input type="checkbox"/>			Off-set <input type="checkbox"/>					
	Turning Sequence <input type="checkbox"/>			Out of Calibration <input type="checkbox"/>					
	Wave/Twist in Tube <input type="checkbox"/>			Out of Sequence <input type="checkbox"/>					

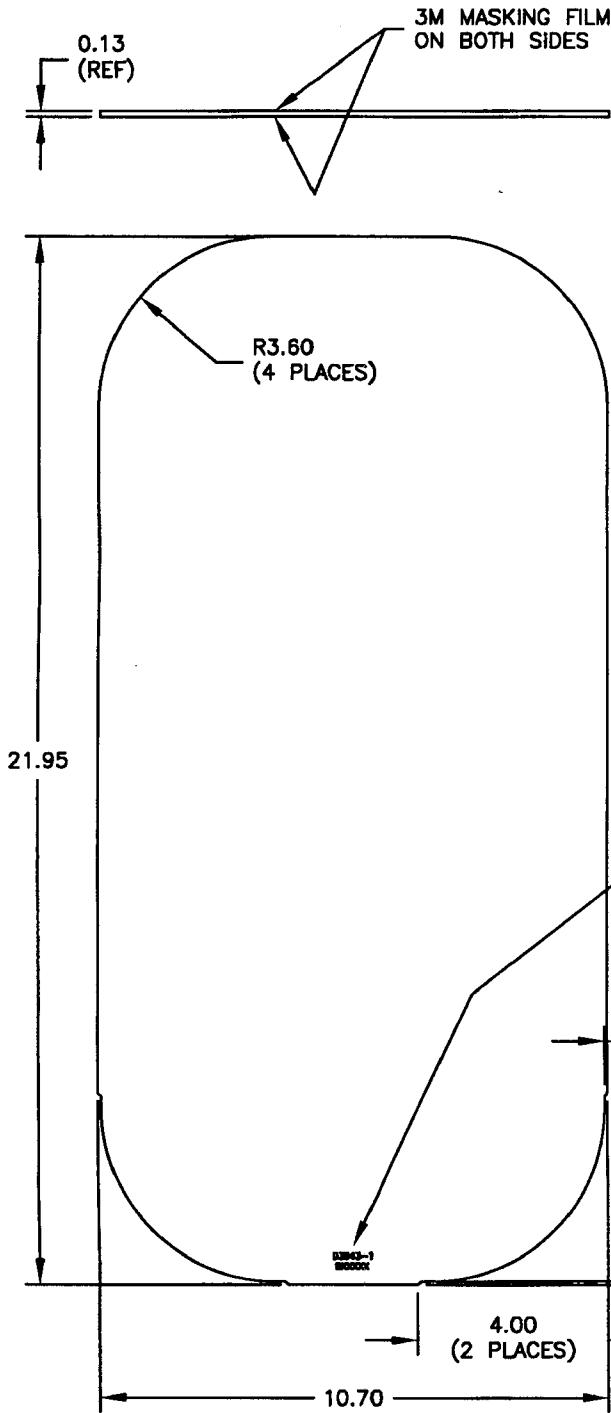
DART AEROSPACE LTD	Work Order:	113663
Description: Hinge Door Push Out Window Frame	Part Number:	D3543-3
Inspection Dwg: D3543      Rev: B		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	<del>MW</del> J.A.	Audited by:	<del>SPM</del>	Prototype Approval:	N/A
Date:	14/05/08	Date:	14/5/08	Date:	N/A

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A	09.05.07	New Issue	KJ/EC	

**DART****D3543-1 HINGE PANEL DOOR PUSH-OUT WINDOW****NOTES:**

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS "G" CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125" THICK (REF DART SPEC. M-ACRYLIC-S.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD	
CHECKED <i>H</i>	APPROVED <i>H</i>	HAWKESBURY, ONTARIO, CANADA	REV. B
DATE 06.11.24	DRAWING NO. D3543	TITLE HINGE DOOR PUSH-OUT WINDOW	SHEET 1 OF 2
A 06.08.01		NEW ISSUE	
B 06.11.24		REMOVE D3568-1 PLACARD; D3543-041 ASS'Y NOT REQUIRED ANYMORE	

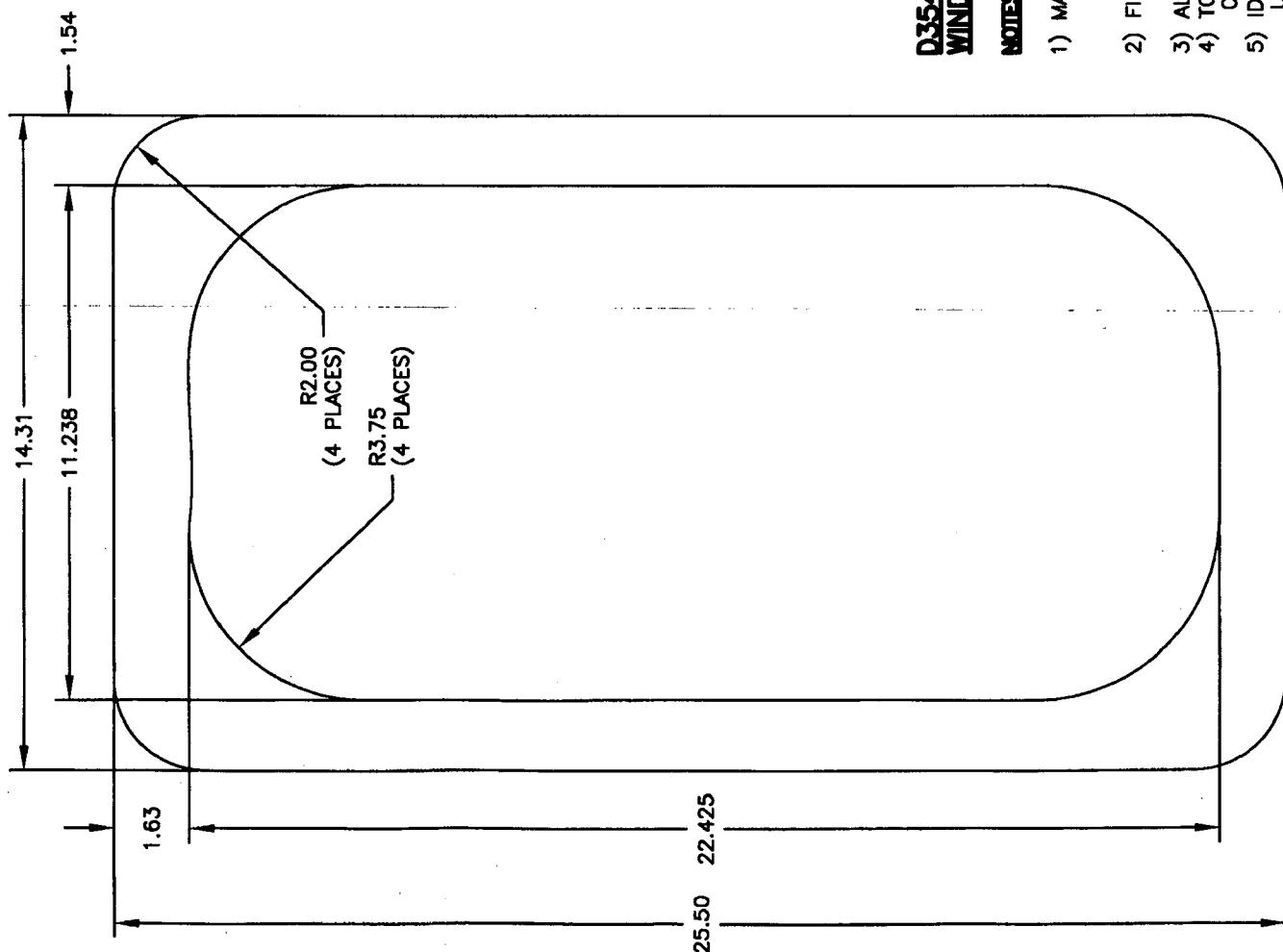
113663 MLJ  
140225  
*H*  
RELEASED  
*H*  
06.12.12

**DART**

DESIGN <i>AB</i>	DRAWN BY <i>AB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>JK</i>	DRAWING NO. D3543	REV. B SHEET 2 OF 2
DATE 06.11.24		TITLE HINGE DOOR PUSH-OUT WINDOW	SCALE 1:4

**RELEASED**06.12.12 - *[Signature]***D3543-3 HINGE DOOR PUSH-OUT  
WINDOW FRAME****NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK  
ALUMINUM SHEET  
(REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER  
DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 01B UNLESS  
OTHERWISE NOTED
- 5) IDENTIFY WITH DART P/N D3543-3 & B/N  
USING FINE POINT PERMANENT MARKER

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